

Work Order ID* 140545

140545

Page 1

Thursday, January 07, 2016 1:26:55 PM

Item ID: D3019-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Back Cushion
 Start Date: 1/7/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/7/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: JAN 07 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3019	B

100	PURCHASING	0.00				DAS 13 9-89	JAN 11 2016	2
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100

Purchasing

Purchasing

Memo

Issue P/O: 30947
 Possible supplier: Chestnut Ridge Airflex fire-resistant aircraft cushioning
 Order: Grade 30-40 (colour green), Density 2.6lb/ft³
 Material must meet FAR 27.853(a) or 25.853(a), Part is symmetric about centerline

110	Receive & Inspect for Damage & Mat'l Certs	0.00				FEB 05 2016	2	68-6 9 SYD
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110

Packaging

Packaging

Memo

Ensure Material Release Note is attached

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 140545

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Page 2

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Item ID: D3019-1 Accept *N900040100* Setup Start *NS1*
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 Item Name: Back Cushion
 Start Date: 1/7/2016 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 1/7/2016 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 38 9.90
120						2			FEB 08 2016
QC	Memo	0.00							
Quality Control	*****REMOVE "CHESTNUT FOAM" LABEL AND ATTACH TO WORK ORDER FOR TRACEABILITY*****								
130	Identify as per dwg & Stock Location: 8415	0.00				2			DAS 6 9.90
130									FEB 08 2016
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							FEB 09 2016
140						ML5			
QC	Memo	0.00							
Quality Control									

ML5 FEB 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Thursday, January 07, 2016 1:26:59 PM

Page 1

Work Order ID: 140545

140545

Parent Item: D3019-1

D3019-1

Parent Item Name: Back Cushion

Start Date: 1/7/2016

Required Date: 1/7/2016

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP: B01.06.07Removed acid etch & alodine EC/SM
11.08.08 added note per NCR 11-588 DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3019-1P		Purchased		No		110	Each	0.0000	1	2			

D3019-1P

Back Cushion

FEB 05 2016

DAS
6
9-89

DQA: _____ Date: _____



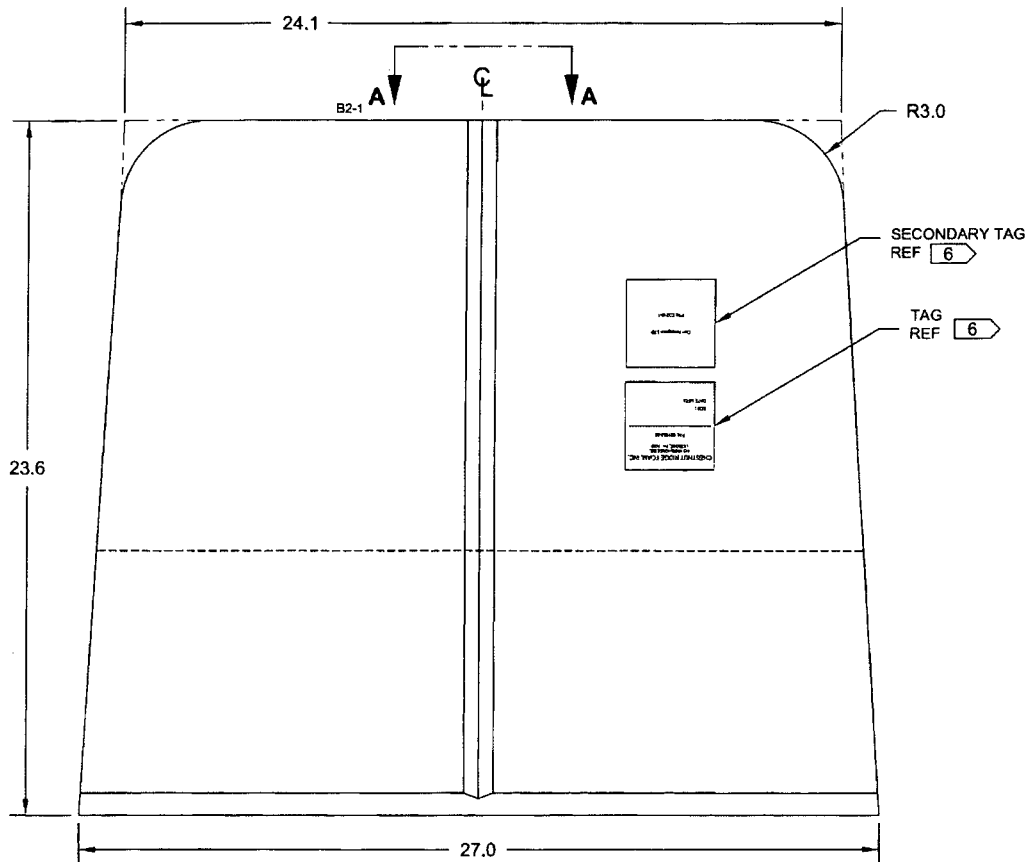
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							

SPECIFICATION CONTROL DRAWING



D3019-1 BACK CUSHION

NOTES:

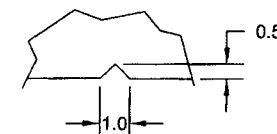
- 1) MATERIAL: MUST MEET FAR 27.853(a) OR 25.853(a)
AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING
GRADE 30-40 (COLOUR GREEN)
DENSITY 2.6 lb/ft³
- 2) FINISH: NONE
- 3) TOLERANCES: PER TABLE 1
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A

- 6) IDENTIFICATION: TAG(S), BURNED, TO SHOW THE FOLLOWING AT MINIMUM:
CHESTNUT RIDGE FOAM, INC.
443 WAREHOUSE DR.
LATROBE, PA 15650
SO#
DATE MFD:
DART AEROSPACE LTD. P/N D3019-1
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE
- 8) MAKE PER TEMPLATE
- 9) POSSIBLE SUPPLIER: CHESTNUT RIDGE P/N 601988-99

TABLE 1

THICKNESS/ HEIGHT	TOLERANCE		LENGTH/ DEPTH	TOLERANCE		WIDTH (LEFT TO RIGHT)	TOLERANCE	
	(+)	(-)		(+)	(-)		(+)	(-)
0.0 - 0.50	0.06	0.06	0.00 - 6.00	0.06	0.06	0.00 - 6.00	0.06	0.06
0.51 - 1.00	0.13	0.06	6.01 - 12.00	0.13	0.13	6.01 - 12.00	0.13	0.13
1.01 - 3.00	0.13	0.06	12.01 - 24.00	0.25	0.25	12.01 - 24.00	0.25	0.25
3.01 +	0.19	0.13	24.01 +	0.50	0.38	24.01 +	0.50	0.38

STOP COPY
RETURN TO
ENGINEERING
FOR CANCELLED COPY
SUBJECT TO A FUTURE
WORK ORDER
NO. 140.545. MJS
1601-07



VIEW A-A
D7-1

RELEASED
2011-05-12
JND

B	UPDATE TO CURRENT STD; DRAWING REVISED IAW CHESTNUT RIDGE MFG DWG. REF: NCR11-588	MB	11.05.10
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	147		
DRAWN	147		
CHECKED	147		
MFG. APPR.	147		
APPROVED	147		
DE APPR.	147		
DATE	11.05.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3019
REV. B
SHEET 1 OF 1
TITLE BACK CUSHION
SCALE NTS

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Chestnut Ridge Foam, Inc.
443 Warehouse Drive
P.O. Box 781
Latrobe PA 15650

Phone: 724-537-9000
Fax: 724-537-9003



Pack Slip: 66938

Packing Slip

Page: 1 of 1

Ship To: Fed Exp #1517-9324-0
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ONTARIO, CANADA K6A 1K7

Phone: 613-632-3336
Fax: 613-632-1053

Sold To: Chantal Lavoie Fax#: 613-632-1053
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ONTARIO, CANADA K6A 1K7

Phone: 613-632-3336
Fax: 613-632-1053

Ship Date: 2/3/2016
Ship Via: Fed Exp Std

F.O.B. Origin

PO Line	Part Number/Description Planned Qty	Shipped Qty	Rev	PO Line
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Sales Order: 54390

Your PO: 30947

Salesperson: Aviation

Certificate of Conformity that all components comply with 14CFR 25.853(a) 12 Second Vertical Bum with Shipment

Line 1 Rel 1

D3018-1P

AIRFLEX Bottom Cushion
2.00 EA

2.00 EA

Our Part: 502148-99

Line 2 Rel 1

D3019-1P

AIRFLEX Back Cushion
2.00 EA

2.00 EA

Our Part: 501988-99

CONTACT CHESTNUT RIDGE FOAM IF THERE IS DAMAGE OR DISCREPANCIES 724-537-9000

16/2/13
SP



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO30947

Purchase Order Date 1/11/2016 8:11:55 AM

PO Print Date 1/11/2016

Page Number 1 of 2

Order From :
CHESTNUT RIDGE FOAM, INC.
PO BOX 6015
HERMITAGE, PA 16148
US

VU-CHE001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JAN 11 2016

Contact Name
Vendor Phone 724 537 9000

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	D3018-1P	Seat Cushion	1/27/2016 Yes 1/27/2016		2.00 Each	\$60.40	\$120.80
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AS PER DWG D3018 REV. B
B140544

Line Total: \$120.80

2	D3019-1P	Back Cushion	1/27/2016 Yes 1/27/2016		2.00 Each	\$46.77	\$93.54
---	----------	--------------	-------------------------------	--	--------------	---------	---------

AS PER DWG D3019 REV. B
B140545

Line Total: \$93.54

Note:

1/11/2016

Chestnut Ridge Foam, Inc.
443 Warehouse Drive
P.O. Box 781
Latrobe, PA 15650

EST



1986

CHESTNUT RIDGE FOAM

Phone: 724-537-9000
Fax: 724-537-9003

Sales Order: 54390

Sales Order Acknowledgement

Page: 1 of 2

Sold To:

Chantal Lavoie Fax#: 613-632-1053
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336

Hawkesbury ONTARIK6A 1K7

Phone: 613-632-3336
Fax: 613-632-1053

Ship To:

Fed Exp #1517-9324-0
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ONTARIO, CANADA K6A 1K7

Fax: 613-632-1053

Order Date: 1/11/2016
Need By: 2/15/2016
Terms: Net 30 Days

PO Number: 30947
Sales Person: Aviation
Ship Via: Fed Exp Std

FOB: Origin
Freight Terms: Collect

If paying by Discover, American Express, VISA, or MasterCard, a nominal fee will be necessary.

Certificate of Conformity that all components comply with 14CFR 25.853(a) 12 Second Vertical Burn with Shipment

Line	Part Number/Description	Rev	Order Qty	Unit Price	Ext Price
1	D3018-1P		2.00 EA	60.40	120.80

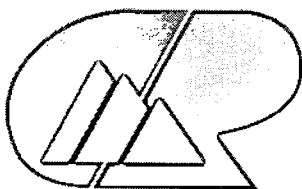
AIRFLEX Bottom Cushion
CRF P/N: 502148-99

Rel	Date	Quantity
1	2/15/2016	2.00

Line	Part Number/Description	Rev	Order Qty	Unit Price	Ext Price
2	D3019-1P		2.00 EA	46.77	93.54

AIRFLEX Back Cushion
CRF P/N: 601988-99

Rel	Date	Quantity
1	2/15/2016	2.00



Chestnut Ridge
Foam, Inc.

**"URGENT! FLAMMABILITY CERTIFICATION
ENCLOSED. PLEASE FORWARD TO
PURCHASING. DO NOT THROW AWAY!"**

Certificate of Conformance

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury
Ontario CANADA K6A 1K7

PURCHASE ORDER: 30947

SALES ORDER: 54390

DATE SHIPPED: 02/03/2016

***I certify that the individual components comprising the part shipped
against the above-referenced purchase order meets the following
requirements:***

14 CFR 25.853(a), APPENDIX F, PART 1(a)(1)(ii), AMENDMENT 25-116

Quantity	Customer Part Number	CRF Part Number	Material	Batch Number
2	D3018-1P	502148-99	CR AIRFLEX (55-65)	AF15041
2	D3019-1P	601988-99	CR AIRFLEX (30-40)	AF15044

MADE IN THE U.S.A

**Robin
Meighen**

Digitally signed by Robin Meighen
DN: cn=Robin Meighen,
o=Chestnut Ridge Foam, Inc.,
ou=Sr. Q.A. Inspector,
email=rmeighen@chestnutridgefo
am.com, c=US
Date: 2016.02.03 11:17:36 -05'00'

❖ 443 Warehouse Drive Latrobe, PA 15650
❖ Phone: 724-537-9000 Fax: 724-537-9003

CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 15886
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : CR AIRFLEX
BATCH / LOT NO : AF15041
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : AFX 55-65

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME
MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F : YES

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : ORANGE

CONDITIONING STARTED : DATE : 12-10-15
TIME : 3:00 PM

TEST STARTED : DATE : 12-14-15
TIME : 8:15 AM

RESULTS :

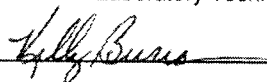
	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	5.0
#2.	0.0	0.0	4.9
#3.	0.0	0.0	5.7
AVG.	0.0	0.0	5.2

PASS : X FAIL :

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,
PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : Kelly Bures
Laboratory Technician



CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 15908
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : CR AIRFLEX
BATCH / LOT NO : AF15044
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : AFX 30-40

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME
MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F : YES

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : GREEN

CONDITIONING STARTED : DATE : 12-31-15
TIME : 11:00 AM

TEST STARTED : DATE : 1-4-16
TIME : 8:05 AM

RESULTS :

	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	3.5
#2.	0.0	0.0	3.8
#3.	0.0	0.0	3.6
AVG.	0.0	0.0	3.6

PASS : X FAIL :

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,
PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : Kelly Bures
Laboratory Technician



